Date: User: Customer Job Number P.O. Number This Issue Prsht Rev. First Issue Written By Comment Job Number: Seq. #: 1.0 2.0

Thursday, 30/08/2007 9:07:16 AM

Linda Lacelle **Process Sheet Drawing Name** : BRACKET : CU-DAR001 Dart Helicopters Services .: 34217 **Estimate Number** : NIA Part Number : D32075 S.O. No. : MA : D3207 REV A : 30/08/2007 **Drawing Number** : N/A Project Number : MACHINED PARTS Type **Drawing Revision** : 34217 Material Previous Run : 06/09/2007 10 Um: Each **Due Date** Checked & Approved By : Est A 04.06.09 **Additional Product** Description: M6061T6S125 6061-T6 .125 Sheet Comment: Qty.: 0.0773 sf(s)/Unit Total: 0.7728 sf(s)6061-T6 .125 Sheet Material: 6061-T6 (QQ-A-250/11) 0.125" thick (M6061T6S.125) Identify for D3207-5 07/08/31 Batch: MIGUUSO FLOW WATER JET WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D3207 Dwg Rev: A Prog Rev:\_\_\_ W 2-Deburr if necessary 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE QC8 SECOND CHECK 4.0

Comment: SECOND CHECK

Date: Thursday, 30/08/2007 9:07:16 AM User: Linda Lacelle **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: BRACKET Part Number: D32075 Job Number: 34217 Job Number: Description: Seq. #: **Machine Or Operation:** NC BRAKE BRAKE NC Comment: NC BRAKE 10 Form as per Dwg D3207 6.0 QC5 Comment: INSPECT WORK TO CURRENT STEP HAND FINISHING1 HAND FINISHING RESOURCE #1 7.0 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 8.0 POWDER COATING 14105642 Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMIC 9.0 Comment: INSPECT CHEMICAL CONVERSION COAT PACKAGING RESOURCE #1 10.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: QC21 11.0 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Date

Thursday, 8/23/2007 11:50:24 AM

User

Kim Johnston

## **Process Sheet**

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

S.O. No. :

Estimate Number

: 11144

P.O. Number

This Issue

: 8/23/2007

Prsht Rev. First Issue

Written By

Comment

Previous Run

: NC

: //

Type

: MACHINED PARTS

: Est A

New issue KJ/RF 04.06.09

**Drawing Number** Project Number

**Drawing Revision Material** 

**Due Date** 

**Drawing Name** 

**Part Number** 

: 9/3/2007

: BRACKET

: D32075

: N/A

: A

- D3207 REV A

Qty:

10 Um:

Each

**Additional Product** 

Checked & Approved By

Job Number:



Seq. #:

Machine Or Operation:

Description:

6061-T6 .125 Sheet

1.0

M6061T6S125

0.0773\sf(s)/Unit Total: Comment: Qtv.:

> 6061-T6 .125 Sheet Material: 6061-T6 (QQ-A-250/11) 0.125" thick

(M6061T6S.125) Identify for D3207-5

Batch: SHEAR

0.7728 sf(s)



Comment: SHEAR

Cut blank: 3.260" x 2.956" grain along 2.956"

3.0

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1

Hell



Comment: HAAS CNC VERTICAL MACHINING #1

Machine D3207-5 as per Folio FA396 and Nwg D3207

Stack of 5

Identify as D3207-5

4.0

QC2

PARTS AS THEY COME OFF MACHINE INSPEC



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

QC8

SECOND CHECK

Comment: SECOND CHECK

Page 1

Form: rorocess

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE By			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
	; ;										
			mal								

Part No: D3207-5 PAR #: MM Fault Category: Prod Fars. AS5' MPNCR: Yes No DQA: Date: 2712/3

QA: N/C Closed: 97. 12. 13

NCR:	3421	WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B		Verification	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector	
<b>७२/७३/३</b> ।	2.0	Wrong Grain direction		Scrop, detroy, replace	SAD 04/08/21	5		Cr	
		R.C. Employee error.	Pasicur		otlessis,	a vol31	Terior	A 081	
ı									
				·					
			· · · · · · · · · · · · · · · · · · ·						

NOTE: Date & initial all entries

Date:

Thursday, 8/23/2007 11:50:24 AM

User:

Kim Johnston

**Process Sheet** 

NC BRAKE

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 34217

Part Number: D32075

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

BRAKE NC





Comment: NC BRAKE

Form as per Dwg D3207

7.0

QC5

INSPECT WORK TO CURRENT STEP



SPECT WORK TO CORREIN STEE



Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

11.0

12.0

DACKACING:

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

QC21

221

FINAL INSPECTION/W/O RELEASE



FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



# **Dart Aerospace Ltd**

W/O:		WORK ORDER CHAN	IGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
Part No		PAR #: Fault Category:	NCR: Yes	No DQ	\:	Date:	
			QA: I	N/C Closed	1:	_ Date: _	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC Corrective Action Section B		Description of NC Corrective Action Section B			Annroyal	Annes		
DATE	Section A Initial	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector			
					-					

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34217
Description: Bracket	Part Number:	D3207-5
Inspection Dwg: D3207 Rev: A		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

		X First Artic	le	Proto	lype
Drawing	Toloranos	Actual	Accept	Reject	Method o
Dimension	Tolerance	Dimension	Accept	Keject	Inspectio

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.926	+/-0.010	2.931	0		Vern	
2.376	+/-0.010	2,382			Vern	
3.200	+/-0.010	3.207			Vern	
R0.25	+/-0.030	RO.25			R-6	
R0.50	+/-0.030	RO.50			R. 6	
R0.75	+/-0.030	RO.75	~		R-6-	
Ø0.438	+0.005/-0.000	Ø0.438	/	-25-705	ilern	
					_	
						4.
					1500	

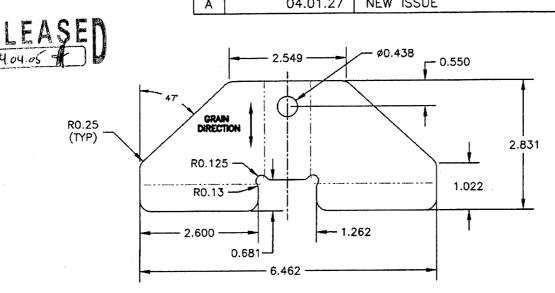
Measured by:	SAO	Audited by:	cr.	Prototype Approval:	N/A
Date:	D7108/31	Date:	03/08/31	Date:	N/A
Data Data	Change			Pavised by	Annrover

Rev	Date	Change	Revised by Approved	a _
A	05.02.17	New Issue	KJ/JLM A Cod	

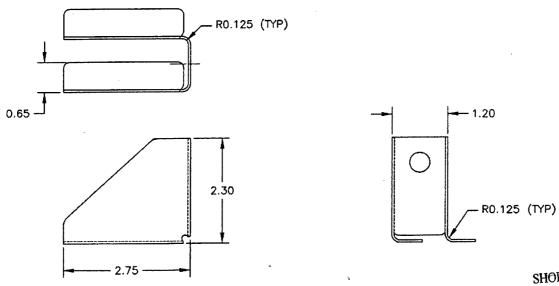




	DESIGN	DRAWN BY		OSPACE LTD ONTARIO, CANADA
	CHECKED	APPROVED,	DRAWING NO. D3207	REV. A SHEET 1 OF 3
	DATE		TITLE	SCALE
	04.01.27		BRACKET	1:2
Ť		04.01.07	NEW ICCLIE	



#### D3207-1/-2 FLAT PATTERN



D3207-1 BEND DETAIL (SHOWN) D3207-2 OPPOSITE

D3107-1/-2 BRACKET

1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.050 THICK (M2024T3S.050)
2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
4 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE INCHES

SHOP COPY RETURN TO **ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER

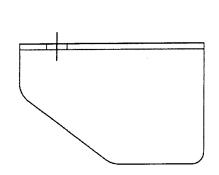
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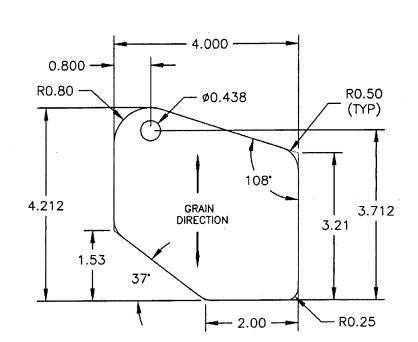
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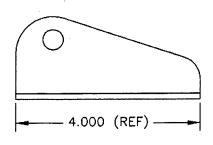
DESIGN	DRAWN BY		ROSPACE LTD y, ontario, canada
CHECKED	APPROVED	DRAWING NO.	REV. A
1 4	W	D3207	SHEET 2 OF 3
DATE		TITLE	SCALE
04.01.27		BRACKET	1:2

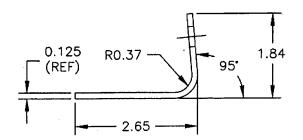






### D3207-3 FLAT PATTERN





### D3207-3 BEND DETAIL

SHOP COPY RETURN TO ENGINEERING

UNCONTROLLED COPY SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER NO.34

D3207-3 BRACKET 1) BREAK ALL UNMARKED SHARP EDGES CORNER 0.005 TO 0.010

2) MATERIAL: 6061-T6 (QQ-A-250/11) 0.125" THICK (M6061T6S.125) 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE INCHES

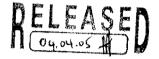
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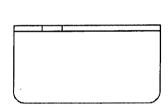
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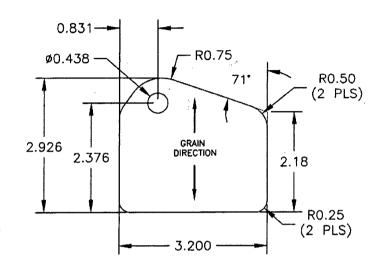




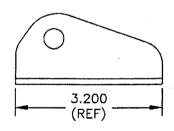
\	DESIGN	DRAWN BY		ROSPACE LTD , ONTARIO, CANADA
)	CHECKED.	APPROVED.	DRAWING NO.	REV. A SHEET 3 OF 3
	DATE		TITLE	SCALE
•	04.01.27		BRACKET	1:2

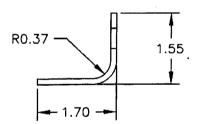






## D3207-5 FLAT PATTERN





D3207-5 BEND DETAIL

SHOP COPY RETURN TO **ENGINEERING** 

UNCONTROLLED COPY SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

2) MATERIAL: 6061-T6 (QQ-A-250/11) 0.125" THICK (M6061T6S.125) 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

1) BREAK ALL UNMARKED SHARP EDGES CORNER 0.005 TO 0.010

POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE INCHES

D3207-5 BRACKET

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